

split

Process Sheet

| | | | | | | | |
|-----------------------|---------------------------------------|--|--|------------------|--|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : BRACKET ASSEMBLY | | |
| Job Number | : 46639 | | | Part Number | : D2803041 | | |
| Estimate Number | : 11029 | | | Drawing Number | : D2803 REV B | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 23/03/2009 | | | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / | | | Due Date | : 03/04/2009 | | |
| Previous Run | : 41672 | | | Qty: | 2 | | |
| Written By | : | | | Um: | Each | | |
| Checked & Approved By | : JULY 09-03-23 | | | Comment | : EST F 05.03.30 MS21043-3 was MS21042L3 | | |
| | KJ/JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|--|-----------------------|-------------------------------|--|--|
| 1.0 | D28031 | Bracket | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 84 BRACKET Pick: Qty Part Number Description Batch 1 D2803-1 Bracket B46610 | | | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STOP Pick: Qty Part Number Description Batch 1 D2805-1 Stop B46735 | | | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing B47733 24 | | | | |
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2803 | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46639

Part Number: D2803041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/05 (10)

6.0 POWDER COATING

POWDER COATING



m 109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(18)

START TIME: 7:15

OVEN TEMPERATURE: 320°

FINISH TIME: 2:45

Fd 09/05/06

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-06 (10)

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

E909/05/22 (2)

E909/05/06 (10)

9.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN3C16A Bolt

M111193

E909/05/06

10.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
2 MS21043-3 Nut

M111383

E909/05/06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 46639

Part Number: D2803041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer 1109268

A/R LPS-3 Corrosion Spray 1109929

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1491

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

mf
09-05-22

| W/O: | | WORK ORDER CHANGES | | | | | |
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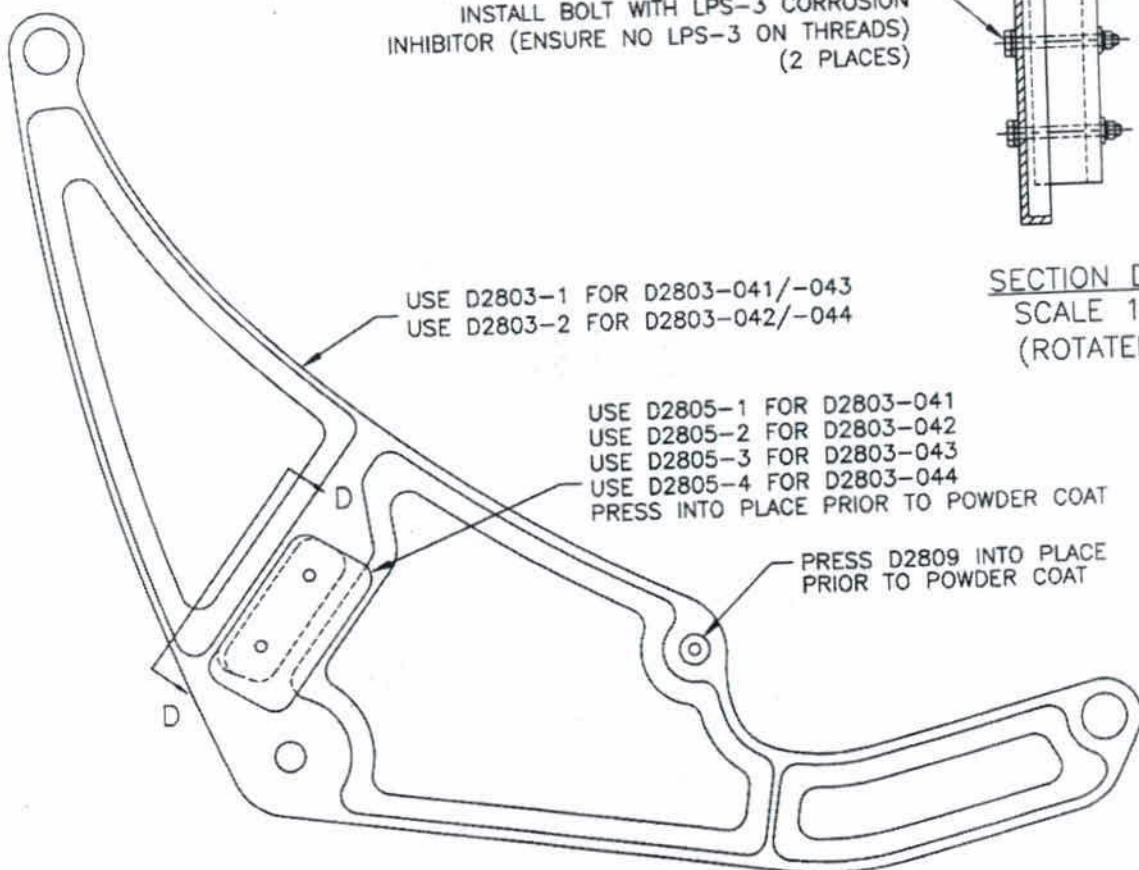
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2803 | REV. B SHEET 2 OF 2 |
| DATE 04.11.22 | | TITLE STA 84 BRACKET | SCALE 1:3 |



SECTION D-D
SCALE 1:3
(ROTATED)

SHOP COPY
RETURN TO
ENGINEERING

RELEASED UNCONTROLLED COPIES SUBJECT TO AMENDMENT

05-03-11 *[Signature]* WITHOUT NOTICE
WORK ORDER
NO. *446051*

D2803-041/-043 BRACKET ASS'Y (SHOWN)

D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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